

Date: Thursday, 3/30/2006 10:06:17 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STEP LEG
Job Number : 26452C	
Estimate Number : 10382	
P.O. Number : N/A	Part Number : D30655
This Issue : 3/30/2006 S.O. No. : N/A	Drawing Number : D3065 REV. A2
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : A2
Previous Run : 26211C	Material : N/A
Written By : <i>SEE COMMENT BELOW</i>	Due Date : 4/15/2006 Qty: 120 Um: Each
Checked & Approved By : <i>06.03.30</i>	
Comment : Est: C 02.11.01 Incorporated D3066-1 IPP KJ/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S080	5052-H32 .080 Sheet
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Comment: Qty.: 1.1338 sf(s)/Unit Total: 136.0548 sf(s)

Material: 5052-H32 (QQ-A-250/8) 0.080" thick
 (M5052H32S.080)

Batch:

M19729 M100112
M100682

2.0	SHEAR	SHEAR
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Comment: SHEAR

Cut blank: 16.61" x 8.51" Grain along 8.51"

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA179 and Dwg D3065-
 Stack of 10
 Identify as D3065-5

Water Jet
cut as per dwg D3065
06.04.24

120

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

06.04.24

120

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

06.04.24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/05/01

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/30/2006 10:06:17 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP LEG

Job Number: 26452C

Part Number: D30655

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr Stack

Mel. F. 06.04.27

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

for 0427 (120)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

H.M 06-04-27

120

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

DL 06-04-27 (120)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 06/05/01

(120)

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SD 06/05/01

Job Completion



W 06-05-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

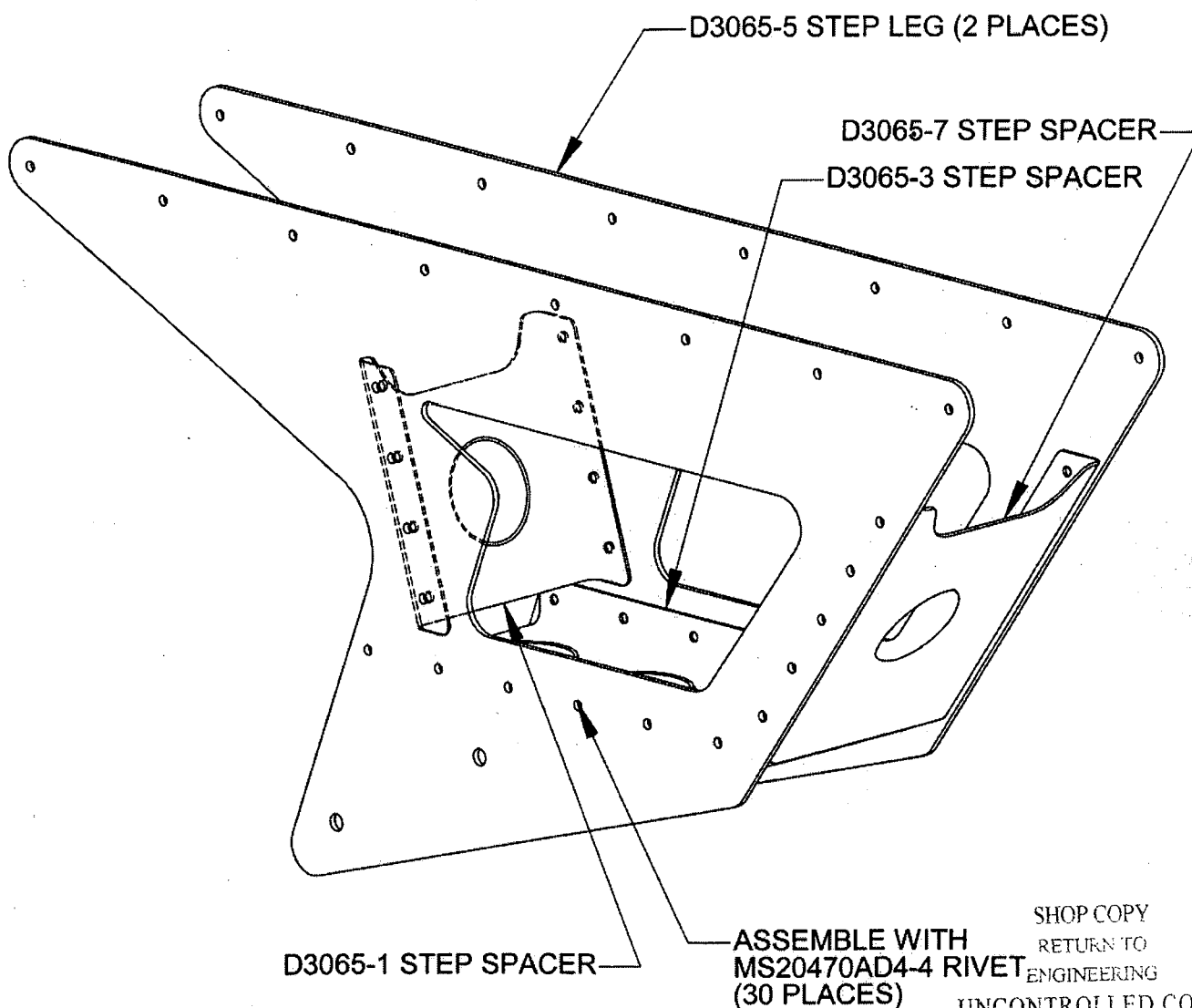
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN QP	DRAWN BY QP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3065	REV. A SHEET 1 OF 5
DATE 02.09.11		TITLE STEP LEG ASSEMBLY	SCALE 1:2
A	02.09.11	NEW ISSUE	
A1	03.02.13 QP	ADD SLOTS TO D3065-5	
A2	03.02.27 QP	0.551 WAS 0.410	

RELEASED
02.09.20 #



D3065-041 STEP LEG ASSEMBLY

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NO. 26452C

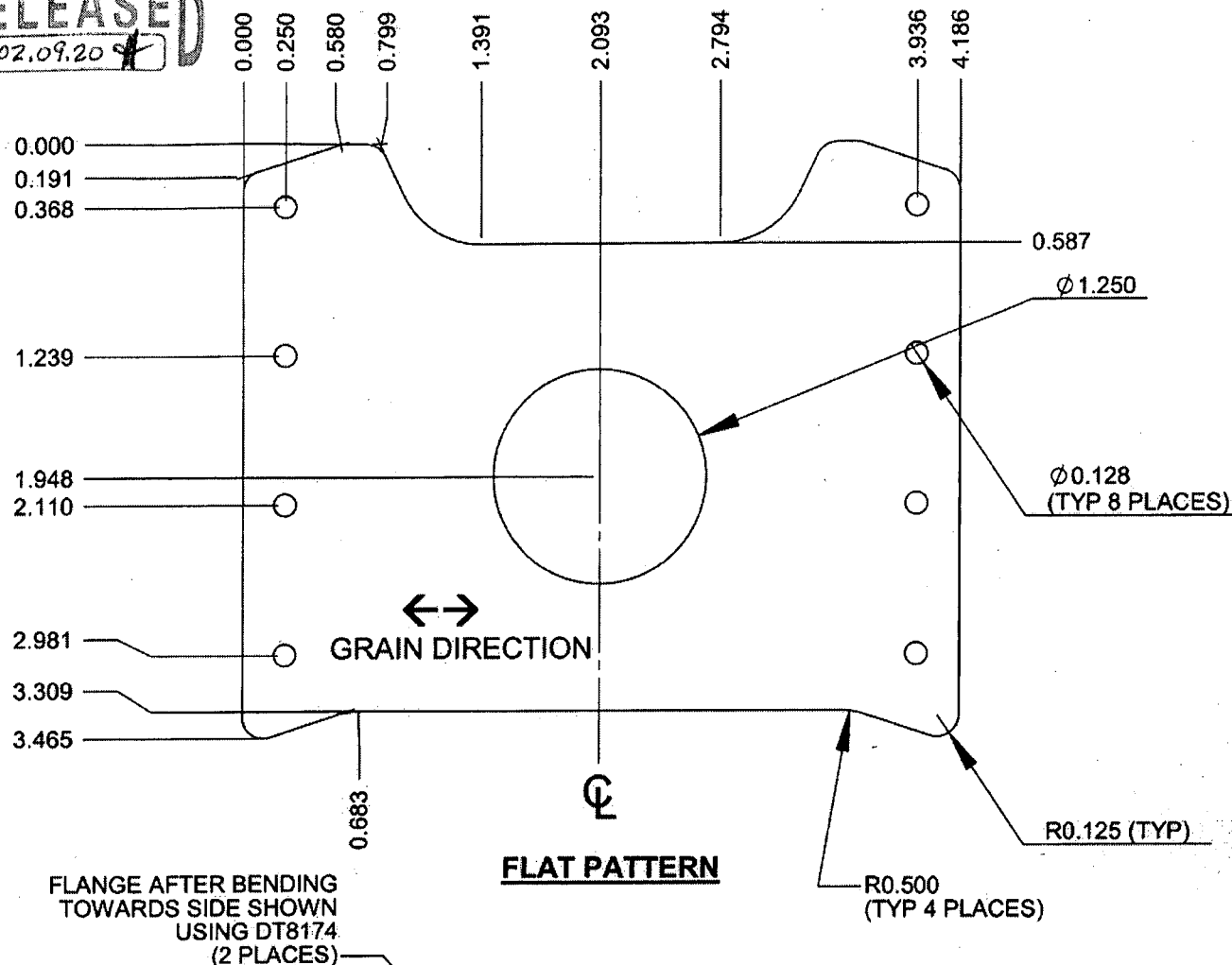
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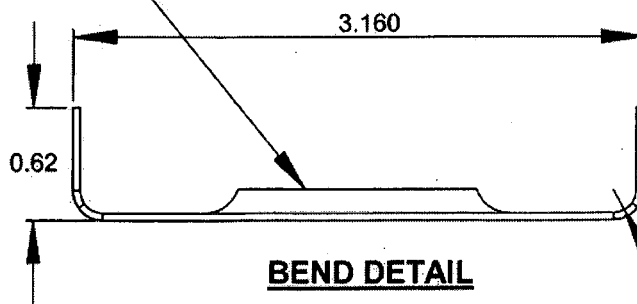


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. A SHEET 2 OF 5
DATE 02.09.11		TITLE STEP LEG ASSEMBLY	SCALE 1:1

RELEASED
02.09.20



FLAT PATTERN



BEND DETAIL

D3065-1 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S-040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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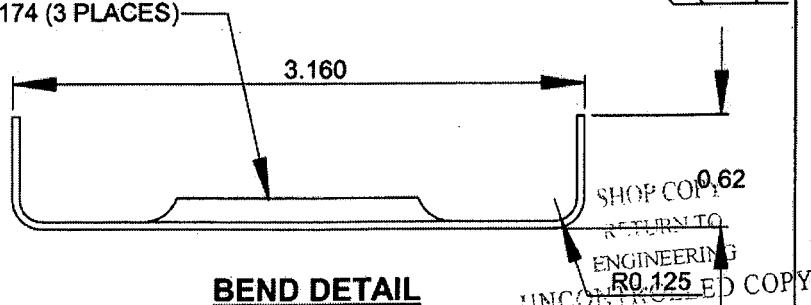
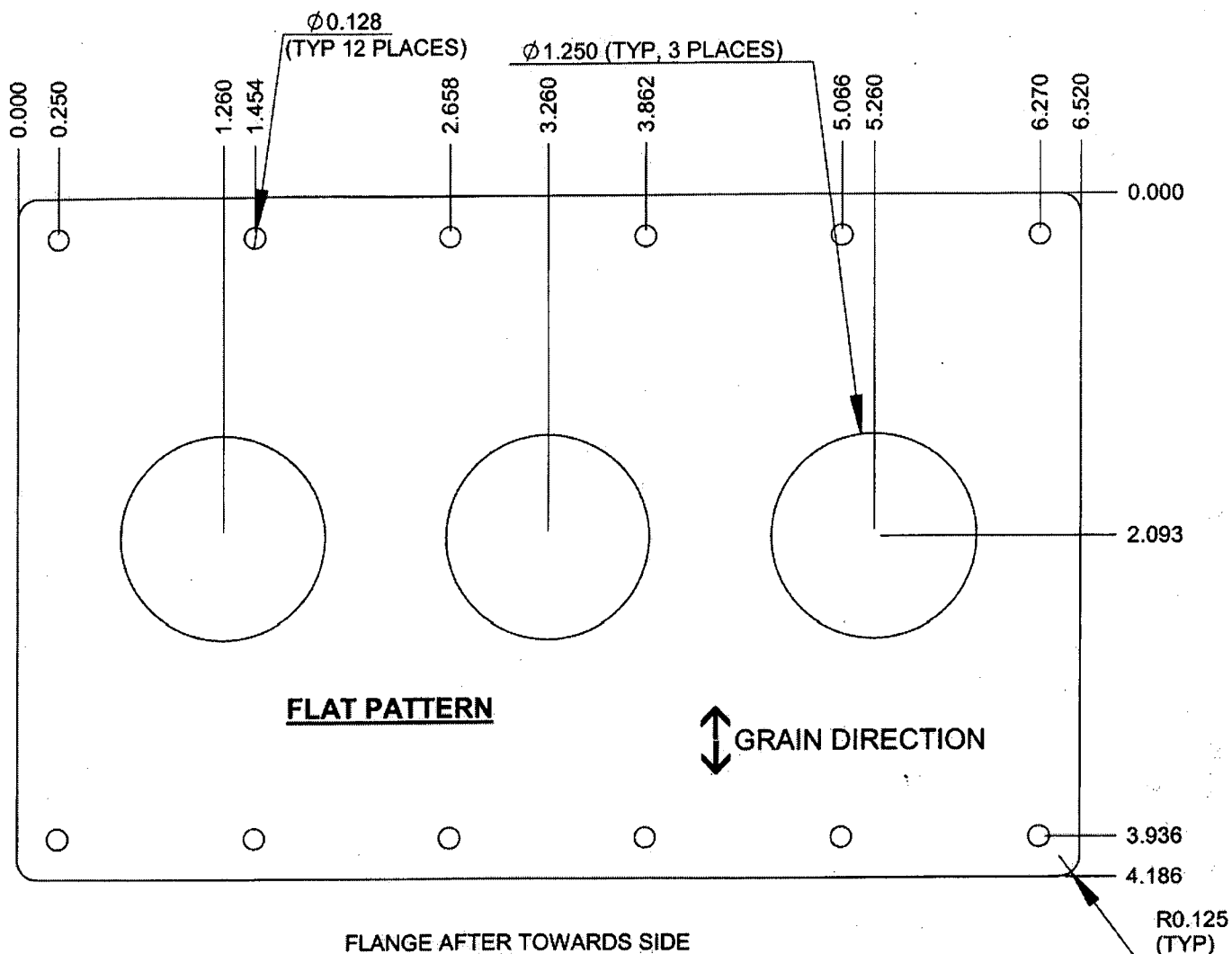
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02.09.20

DART



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DATE 02.09.11		TITLE STEP LEG ASSEMBLY	SCALE 1:1



D3065-3 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

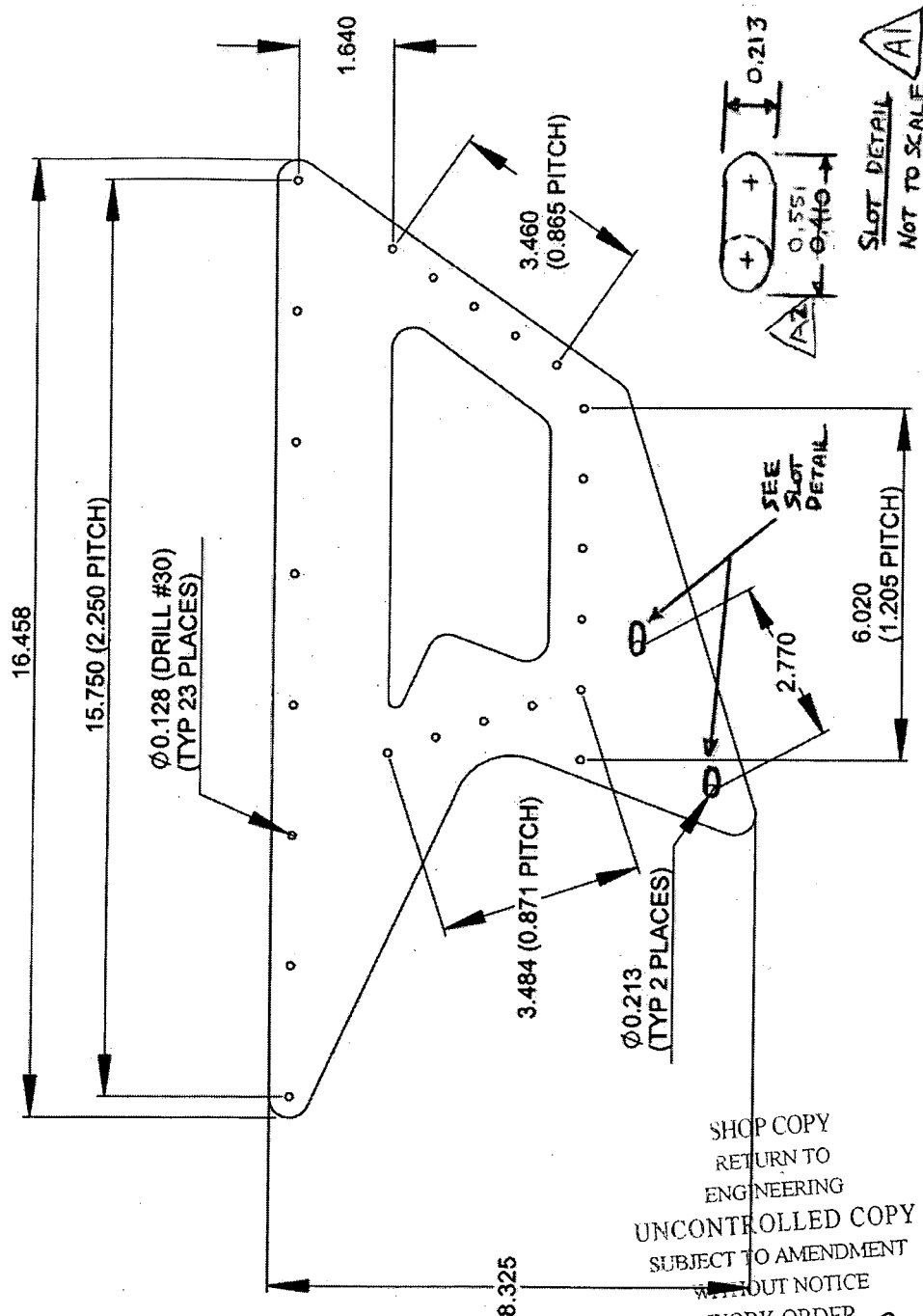
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NO. 26452C

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DATE 02.09.11	TITLE STEP LEG ASSEMBLY		SCALE 1:3

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NO. **26452C**

D3065-5 STEP LEG

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 5052-H32 (QQ-A-250/8) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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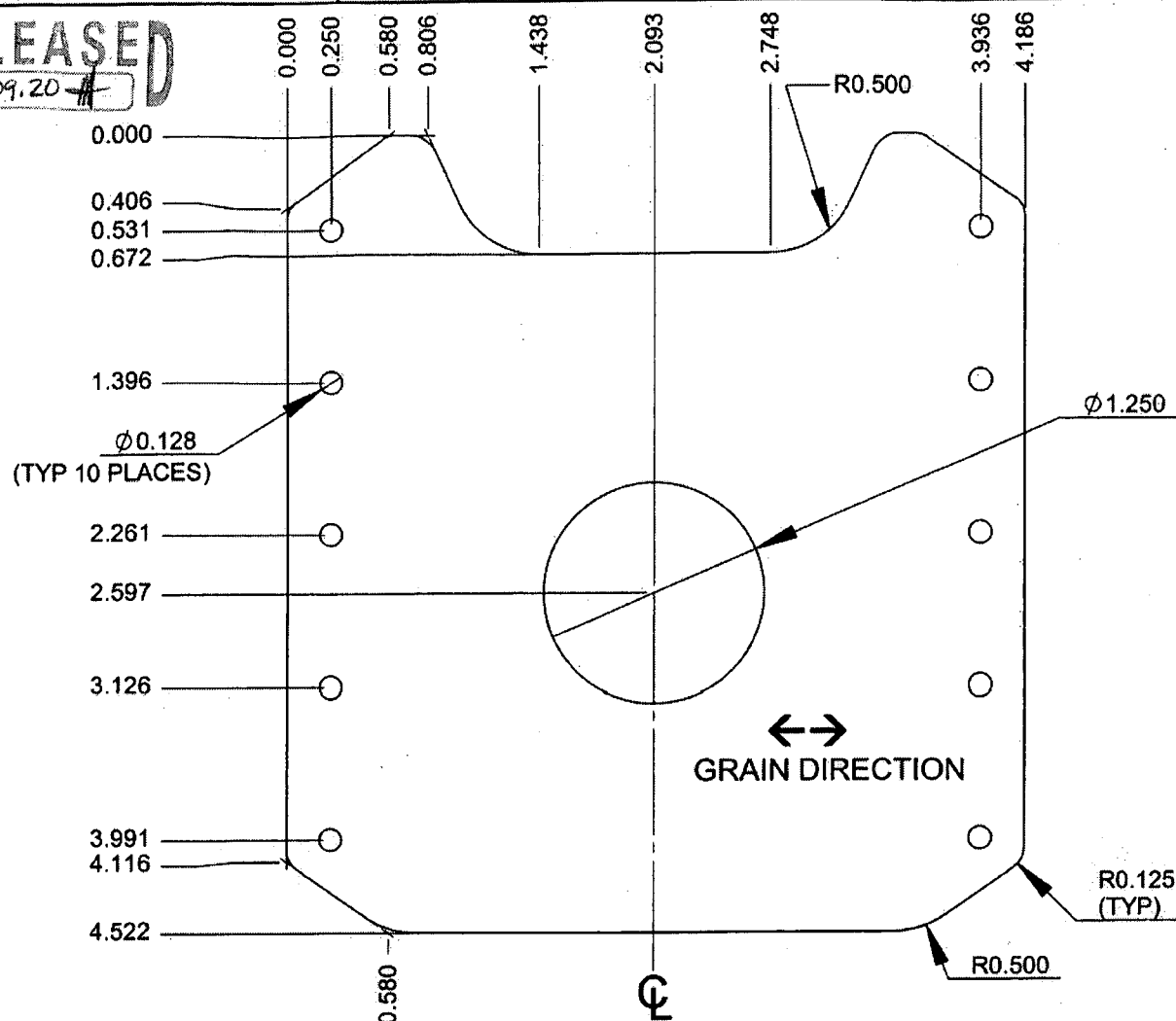
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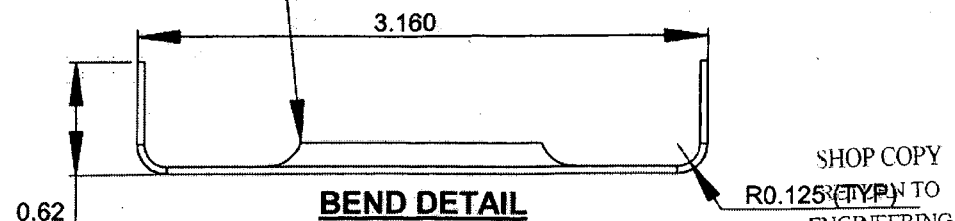
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DATE 02.09.11		TITLE STEP LEG ASSEMBLY	SCALE 1:1

RELEASED
02.09.20 *#*



FLANGE AFTER BENDING TOWARDS
SIDE SHOWN USING DT8174 (2 PLACES)

FLAT PATTERN



BEND DETAIL

D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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